

Work Order ID 144128

April 04, 2016 3:12:43 PM

144128

Page 1

Item ID: D4039-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Bracket Assembly
 Start Date: 4/20/2016 Start Qty: 1.00 ***4*** **5/5/16** Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 1.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: SLA Date: 20160405 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4039	B								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble lanyard to bracket as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>SL76</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89

DAS
38
9-89

MAY 06 2016

DAS
6
9-89

MAY 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

Item ID: D4039-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Fwd Bracket Assembly
Start Date: 4/20/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/24/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

16/5/9 *[Signature]*

[Signature] 20160506

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Page 1

April 04, 2016 3:13:19 PM

Work Order ID: 144128

144128

Parent Item: D4039-041

D4039-041

Parent Item Name: Fwd Bracket Assembly

Start Date: 4/20/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.12.15 verified by:EC

IPP REV

B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
D4039-1		Manufactured	No			100	Each	0.0000	1	24			9-89

D4039-1

Fwd Bracket

**

144139

D2690-6

Manufactured No

100

Each

18.0000

1

24

D2690-6

Lanyard

**

DAS

36

9-89

B145224 (X)

Location

Loc Qty

Loc Code

ST009

6

142782

6

ST012a

12

142876

12

BLRS-010

Purchased

No

100

Each

22.0000

1

24

BLRS-010

Quick Release Pin (1/4" x 1")

**

DAS

8

9-89

Location

Loc Qty

Loc Code

FG

4

121374

4

ST557

18

m132518

10

m132935

8

4

Picklist Print

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Work Order ID: 144128

144128

Parent Item: D4039-041

D4039-041

Parent Item Name: Fwd Bracket Assembly

Start Date: 4/20/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-11

Purchased

No

100

Each

198.0000

1

27

MS27039-1-11

**

Screw

DAS
6
8-89

Location

Loc Qty

Loc Code

CA	178
124326	178
GA	20
125654	13
9662	7

4

MS21042L3

Purchased

No

100

Each

2,067.000

1

27

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

FP001	100
m133790	100
GA	798
m133790	6
m134360	792
Return2016	1
M132382	1
ST304	1168
m134039	12
m134360	1156

4

MAY 04 2016

DAS
6
8-89

Picklist Print

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Work Order ID: 144128

144128

Parent Item: D4039-041

D4039-041

Parent Item Name: Fwd Bracket Assembly

Start Date: 4/20/2016

Required Date: 5/24/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

100

Each

2,280.000

3

318

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

598

m134055

598

Return2016

2

m132317

2

ST260a

1000

m134606

1000

ST263

680

m134370

680

3

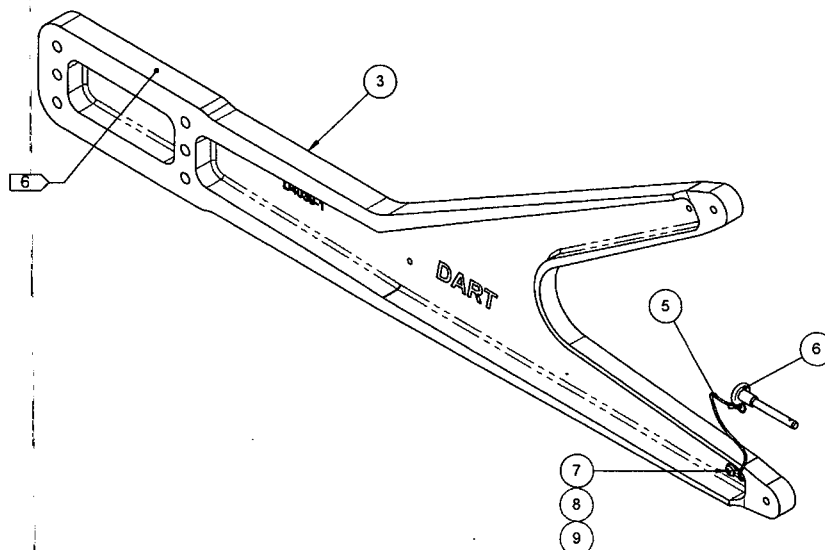
880 50
MAY 04 2016

April 04, 2016 3:13:19 PM

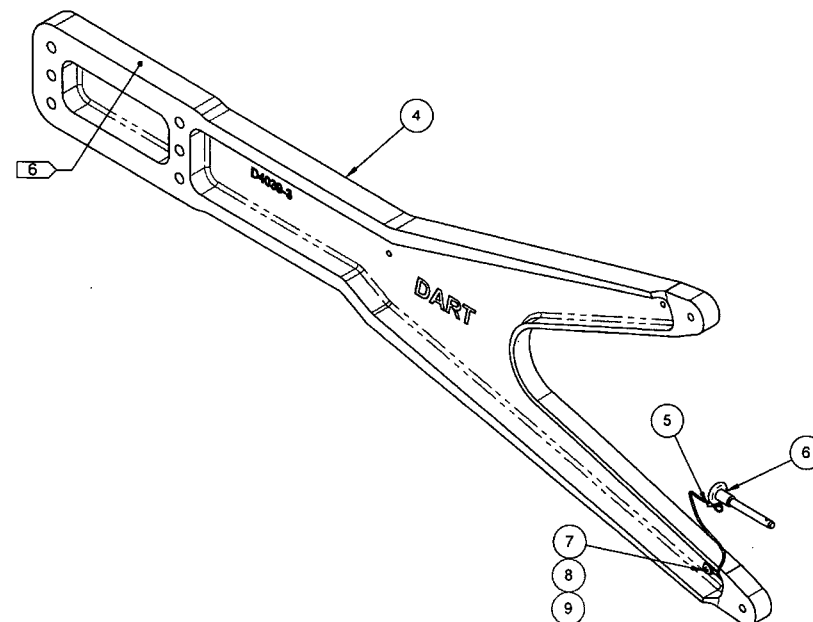
Shop Packet Print

Page 3

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

RELEASED
2010-09-27

20160405
SA
144128

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: N/A

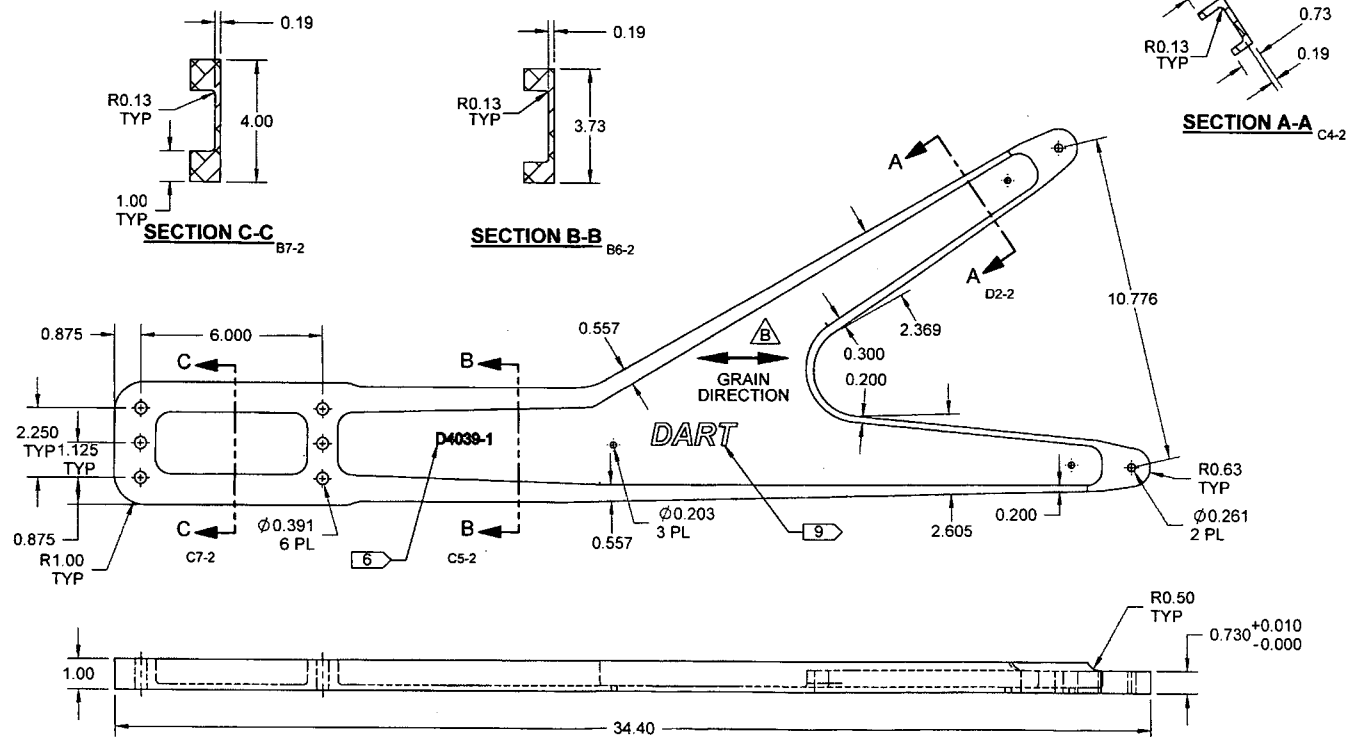
B

B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. B
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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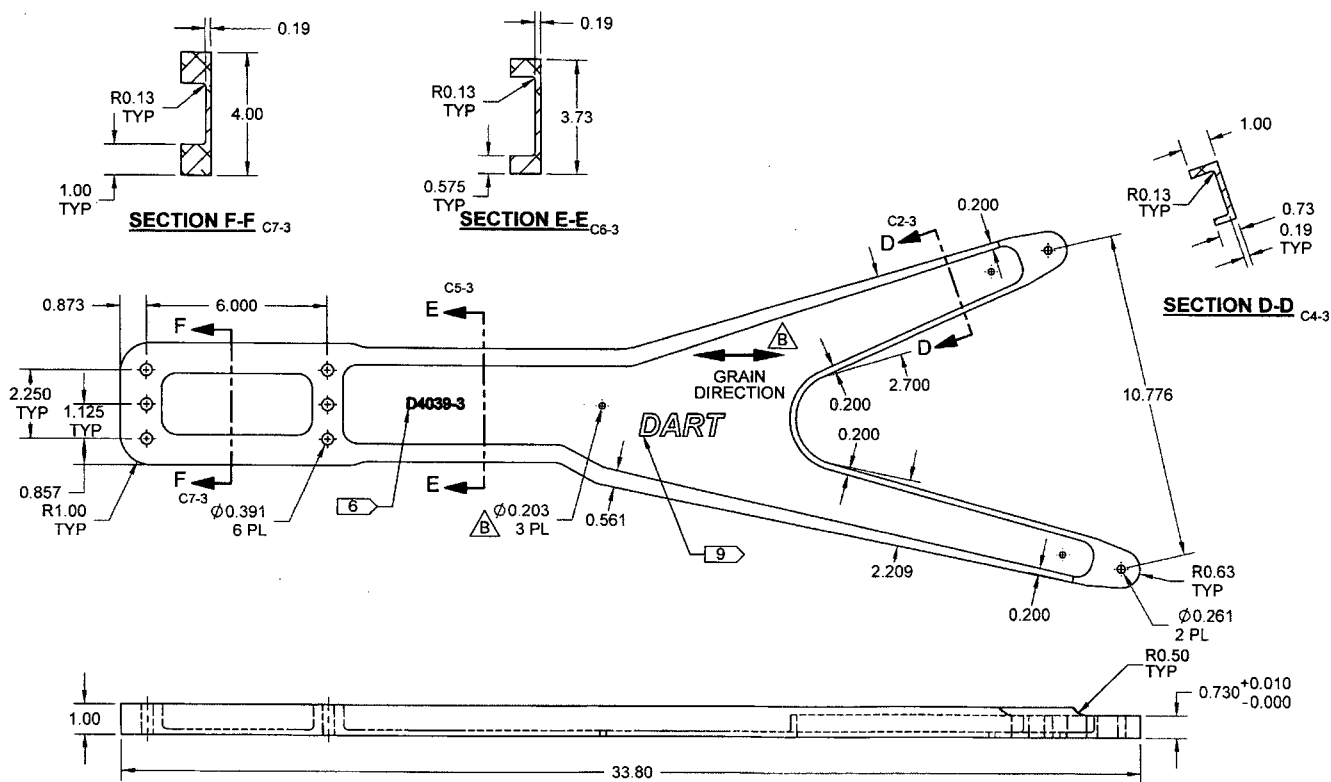
D4039-1 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1_REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-09-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR/AMS 4025 OR AMS 4027
OR/ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3_REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4039	REV. B
MFG. APPR.		TITLE BRACKET	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		DATE 10.04.28	
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RELEASED
2010-09-27